

Work Order ID **74251**

Page 1

Tuesday, September 27, 2011 12:53:27 PM

Item ID: D4131-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Manifold Assembly

Start Date: 9/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/12/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4131

B

100

Weld per dwg A/R S.S. rod Batch: M114507 0.00

Large Fab

Memo

0.00

Large Fab

EL 11-12-15

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

QC 11-12-1716x

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

QC 11-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


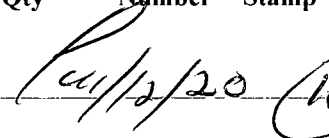

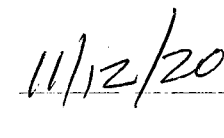
Work Order ID 74251


Page 2

Tuesday, September 27, 2011 12:53:27 PM

Item ID: D4131-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Manifold Assembly
Start Date: 9/27/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 10/12/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo 132	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11-12-20 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 12:53:25 PM

Page 1

Work Order ID: 74251

Parent Item: D4131-041

Parent Item Name: Manifold Assembly



Start Date: 9/27/2011

Start Qty: 10.00

Required Date: 10/12/2011

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC
11.09.26 AS PER REV.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4131-045		Manufactured	No			100	Each	0.0000	1	10			
Base Assembly													

D4131-1		Manufactured	No			100	Each	4.0000	1	10			
Front Plate													

				Location	Loc Qty	Loc Code							
				ST131	4		4						
				72468	4		4						
D4131-5		Manufactured	No		100	Each	10.0000	2	20				
Side Plate													

				Location	Loc Qty	Loc Code							
				ST131	10		8						
				72470	10		8						
74256 X 24													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

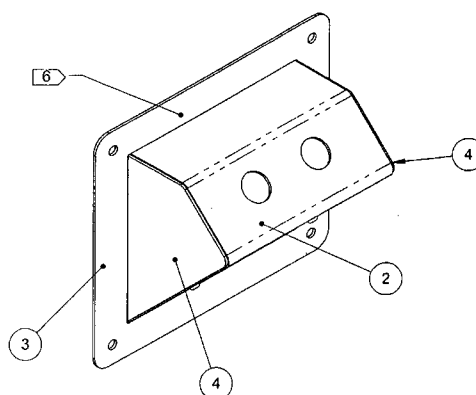
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-045	BASE ASSEMBLY
3	1	D4131-1	FRONT PLATE
4	2	D4131-5	SIDE PLATE



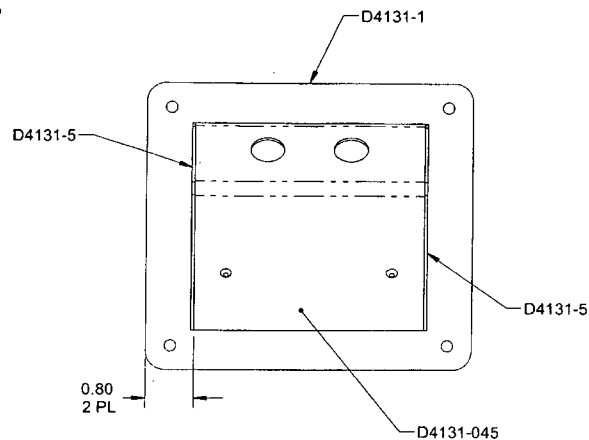
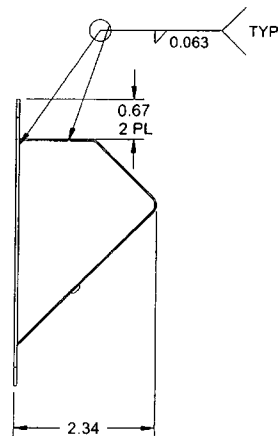
D4131-041 MANIFOLD ASSEMBLY

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs

B	D4131-045 WAS D4131-3 (ZN D3-1); ADD 4131-045 (ZN B4-3); ADD Ø0.098 (ZN B4-7); ADD 4131-9 (ZN B5-10)	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D4131	SHEET 1 OF 10
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	MANIFOLD ASSEMBLY	NTS
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D4131-041 MANIFOLD ASSEMBLY

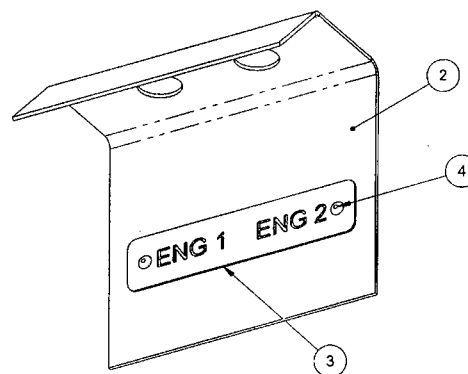
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs
- 8) WELD PER DART QSI 004

RELEASED
2011-09-21

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MFG. APPR.	<i>MP</i>	D4131	SHEET 4 OF 10
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET



D4131-045 BASE ASSEMBLY

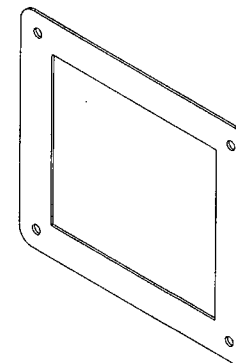
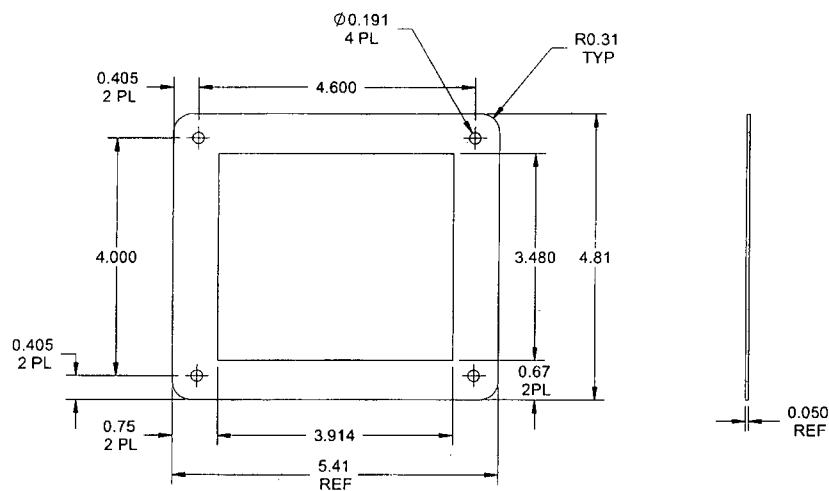


RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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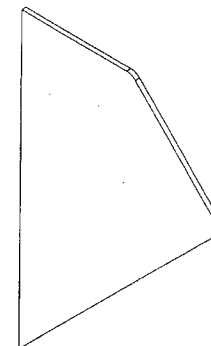
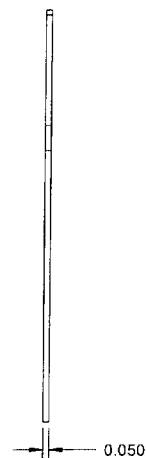
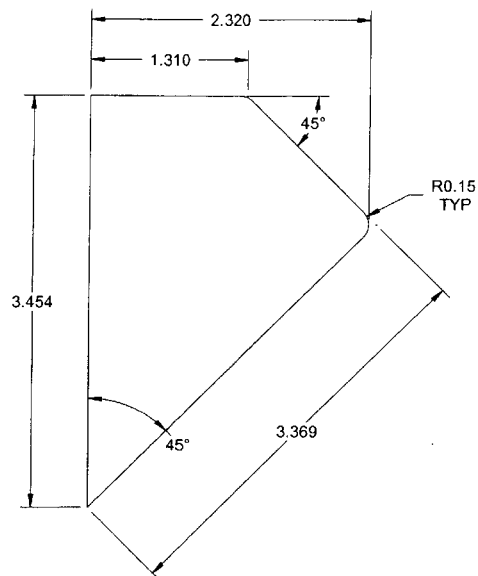
D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

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MFG. APPR.	<i>SS</i>	D4131	SHEET 5 OF 10
APPROVED	<i>MD</i>	TITLE	SCALE
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RELEASED
2011-09-21
JW



D4131-5 SIDE PLATE

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
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MFG. APPR.	<i>DS</i>	D4131	SHEET 8 OF 10
APPROVED	<i>MP</i>	TITLE	SCALE
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